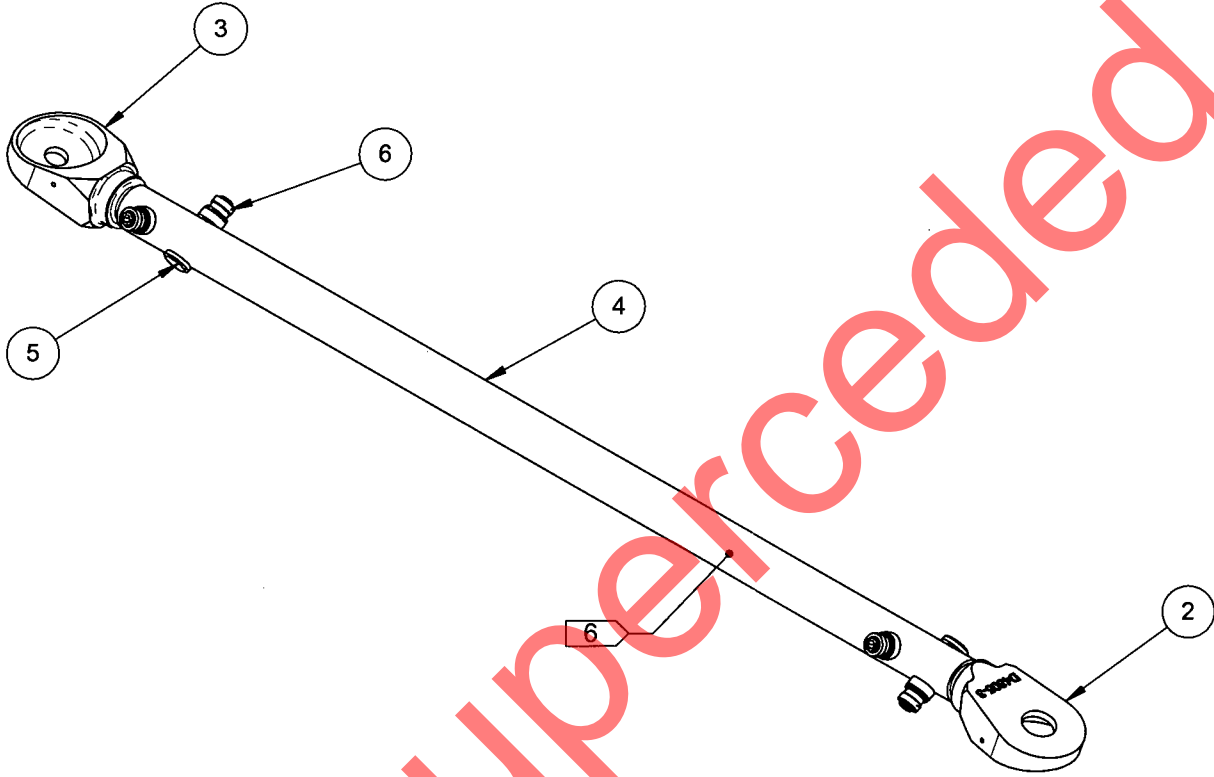


ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4834-041	LEG ASSEMBLY, LH
2	1	D4805-3	END FITTING
3	1	D4805-5	END FITTING
4	1	D4834-1	STRUT
5	4	HL20PB5-8	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4834-041 LEG ASSEMBLY, LH

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.55 lbs
 - 8) ALIGN PILOT HOLES IN D4834-1 WITH PILOT HOLES IN D4805-3 & D4805-5.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9955
 - 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA WHILE STILL WET
 - 10) ASSEMBLE PER DART TOOL DT9955
 - 11) INSTALL HL20PB5-8 HI-LOK IN ORIENTATION SHOWN

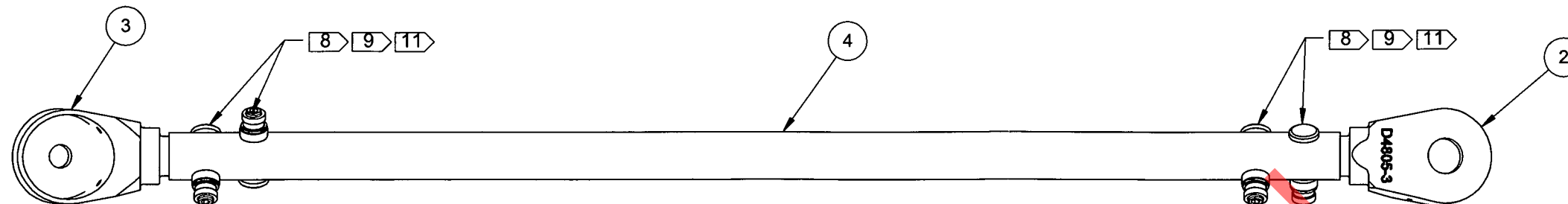
APPROVED

A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4834	SHEET 1 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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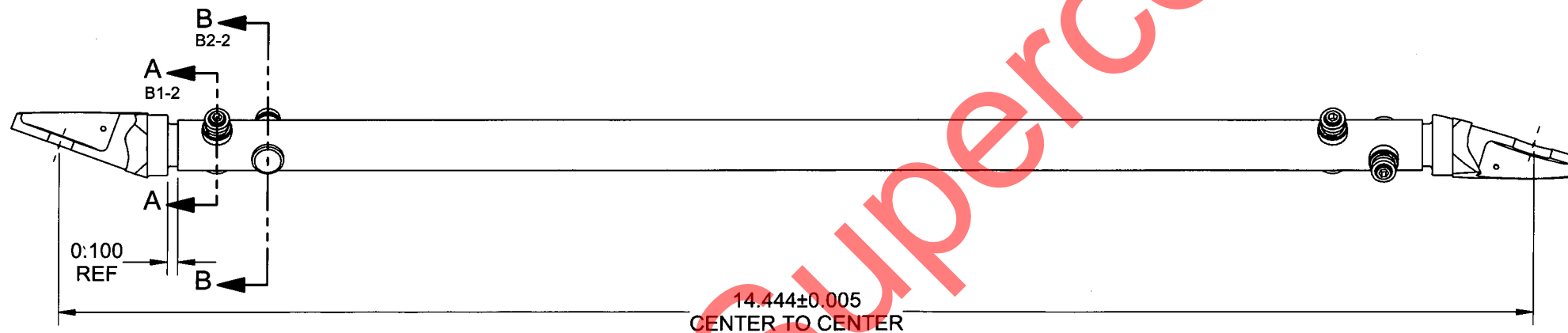
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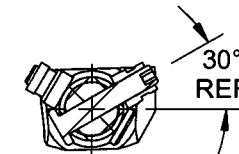
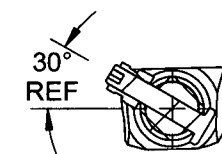
C

C



B

B



SECTION A-A B7-2
2 PL SIMILAR

SECTION B-B B7-2
2 PL SIMILAR

D4834-041 LEG ASSEMBLY, LH
AUXILIARY VIEW

RELEASED
11 2016-01-03

A

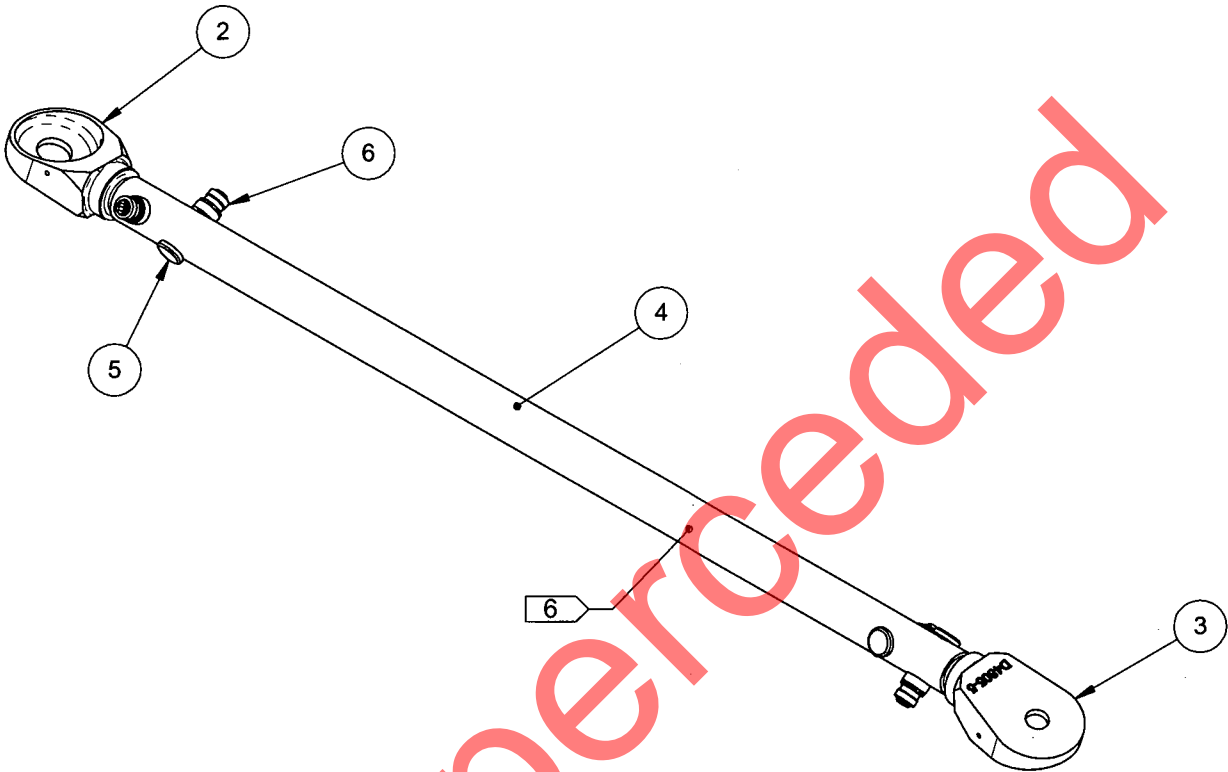
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APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	HS	DRAWING NO. D4834	REV. A
MFG. APPR.	JLM	SHEET 2 OF 6	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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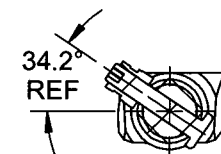
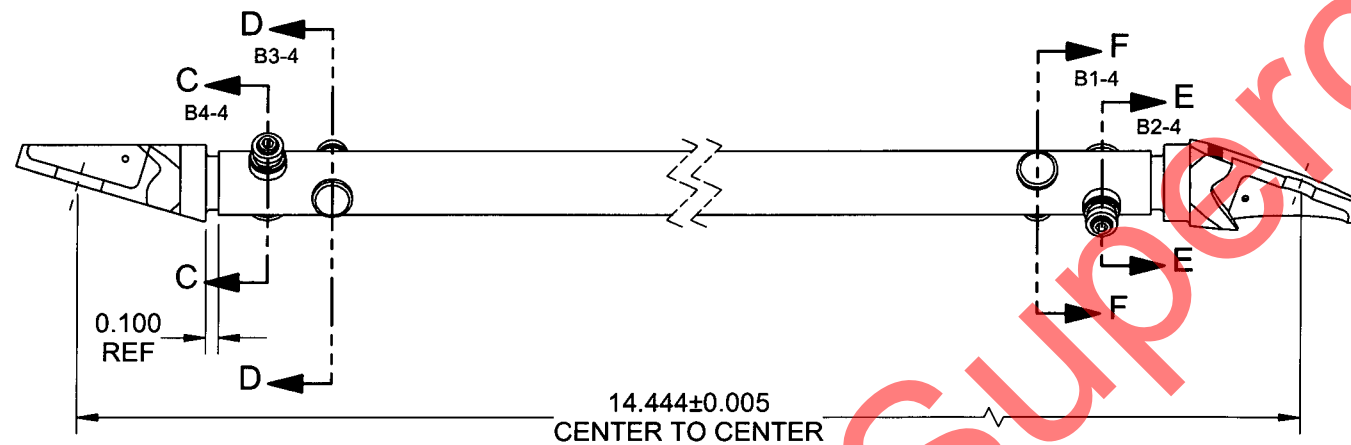
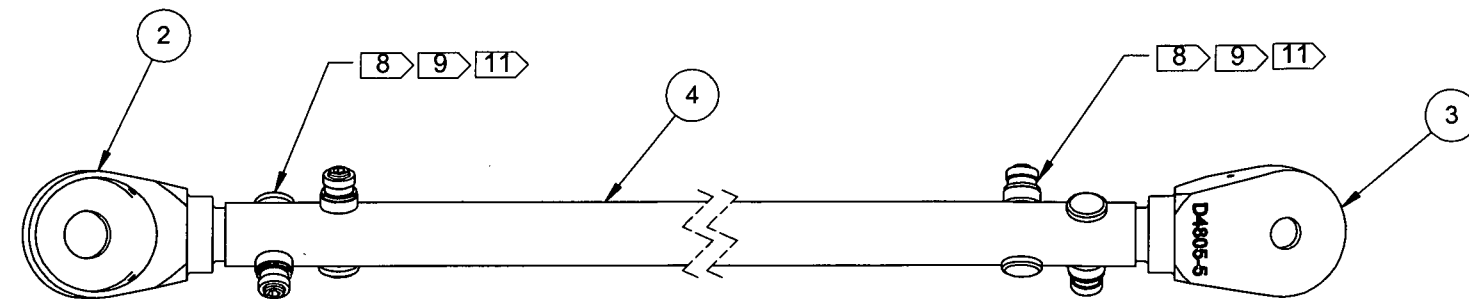
ITEM NO.	QTY. -042	PART NUMBER	DESCRIPTION
1	X	D4834-042	LEG ASSEMBLY, RH
2	1	D4805-3	END FITTING
3	1	D4805-5	END FITTING
4	1	D4834-2	STRUT
5	4	HL20PB5-8	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



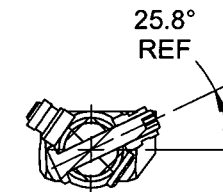
D4834-042 LEG ASSEMBLY, RH

- NOTES:**
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.55 lbs
8) ALIGN PILOT HOLES IN D4834-2 WITH PILOT HOLES IN D4805-3 & D4805-5.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9956
9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA WHILE STILL WET
10) ASSEMBLE PER DART TOOL DT9956
11) INSTALL HL20PB5-8 HI-LOK IN ORIENTATION SHOWN

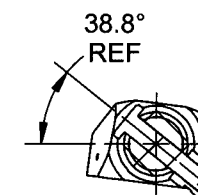
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	DRAWN	RF		
	CHECKED	HS	DRAWING NO. D4834	REV. A
	MFG. APPR.	JLM	SHEET 3 OF 6	
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	LEG ASSEMBLY	NTS
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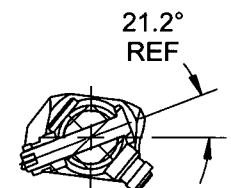
SECTION C-C B8-4



SECTION D-D B8-4



SECTION E-E B5-4

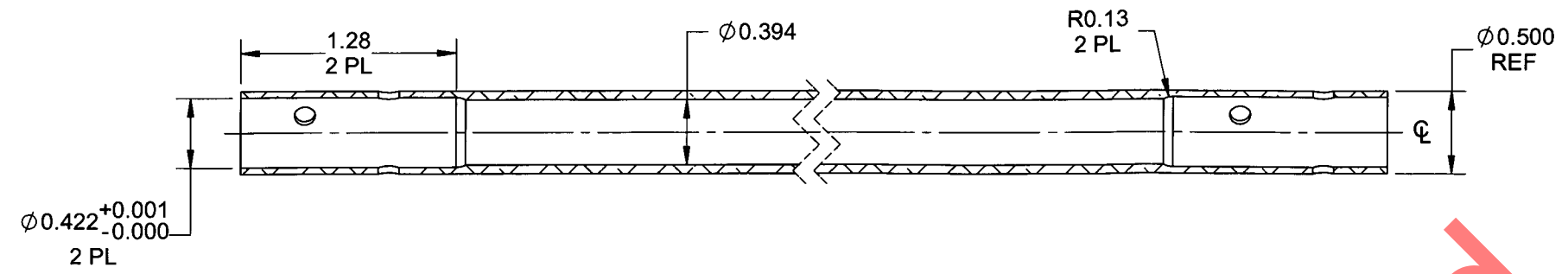


SECTION F-F B5-4

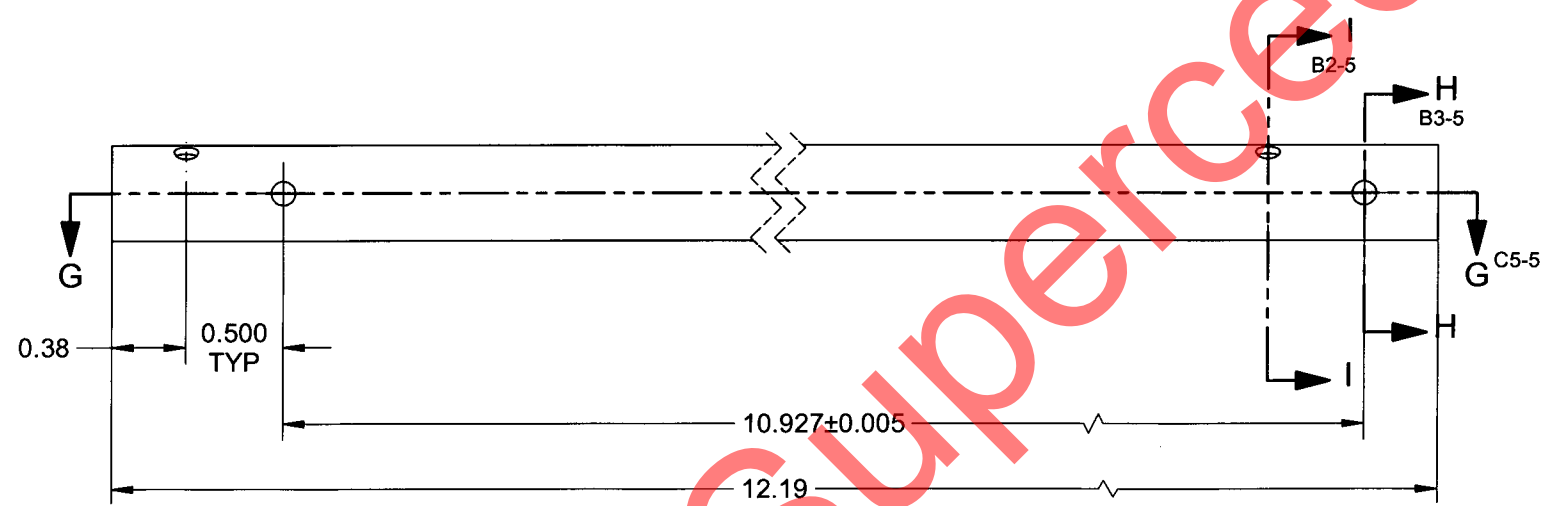
D4834-042 LEG ASSEMBLY, RH
AUXILIARY VIEW

APPROVED

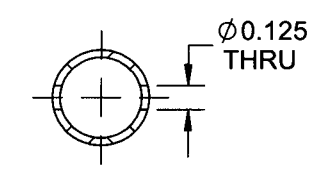
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DRAWN	RF		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4834	SHEET 4 OF 6
APPROVED	HS	TITLE	SCALE
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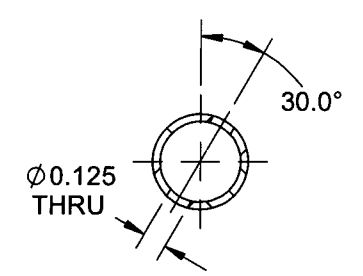
SECTION G-G B4-5



D4834-1 STRUT



SECTION H-H C4-5
2 PL



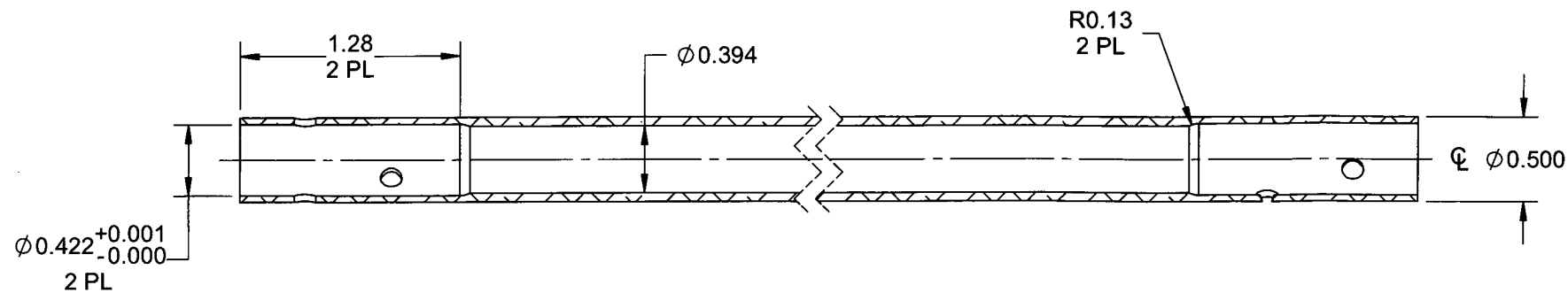
SECTION I-I C4-5
2 PL

NOTES:

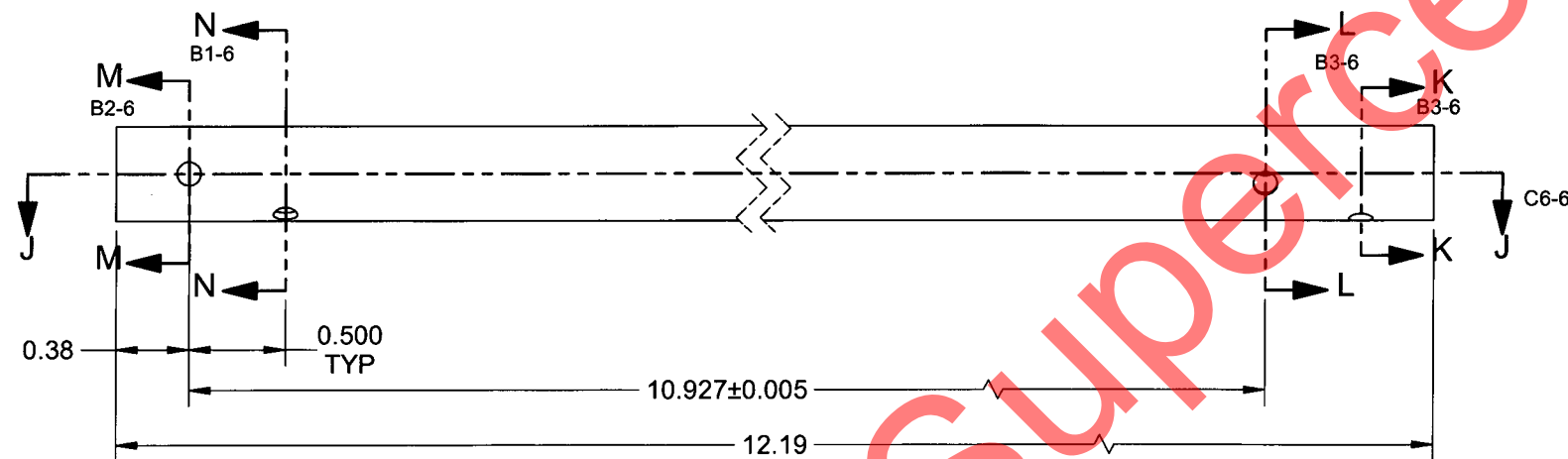
- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.25 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

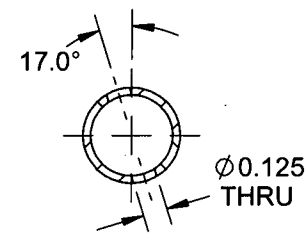
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DRAWN	RF		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4834	SHEET 5 OF 6
APPROVED	HS	TITLE	SCALE
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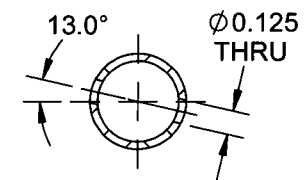
SECTION J-J C4-6



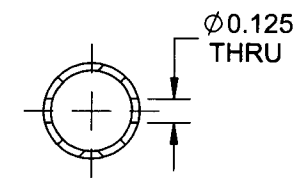
D4834-2 STRUT



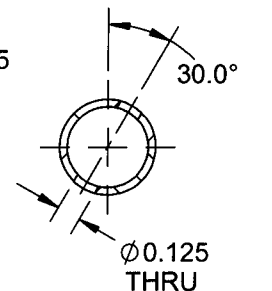
SECTION K-K B4-6



SECTION L-L B5-6



SECTION M-M B8-6



SECTION N-N B7-6

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPER 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	HS	DRAWING NO. D4834	REV. A
MFG. APPR.	JLM		SHEET 6 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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